








# Work Order ID 52581

October 02, 2009 10:36:07 AM

Page 1


Item ID: D205-523-013 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Heli Rappel, 500lb  
Start Date: 10/02/09 Start Qty: 4.00  Cust Item ID:  
Required Date: 10/09/09 Req'd Qty: 4.00  Customer:  
Reference: Return 2009/ RA109102

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: N/A Date: \_\_\_\_\_ Run Start   
QC: 2 mp Date: 09/02 SPC (Y/N): N/A Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DS19301	Rev A

100	QC5- Inspect part completeness to step on W/O	0.00							
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 QC Memo 0.00


Quality Control Returned are the following originals:  
3x D205-523-013 B51057 @ CHG002  
1x D205-523-013 B48671 @ CHG002 278 09/10/02

110		0.00							
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 HandFinish Memo 0.00 MD 09/10/05 xy

Hand Finishing Touch up part with alodine & with white Imron per QSI005, as necessary.

120	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

 QC Memo 0.00 BK 09-10-6 (4)  
MD 09

Quality Control

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON. CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D205-523-013	CHG	CHG002		
DESC.	Heli-Rappel Kit	STC	SH96-90		
LOT	B51057	STC	SR00511/2NY		
MODEL	Bell 205/212/214/412	STC	SR00513NY		
MADE IN CANADA					

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON. CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D205-523-013	CHG	CHG002		
DESC.	Heli-Rappel Kit	STC	SH96-90		
LOT	B51057	STC	SR00511/2NY		
MODEL	Bell 205/212/214/412	STC	SR00513NY		
MADE IN CANADA					

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON. CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D205-523-013	CHG	CHG002		
DESC.	Heli-Rappel Kit	STC	SH96-90		
LOT	B48671	STC	SR00511/2NY		
MODEL	Bell 205/212/214/412	STC	SR00513NY		
MADE IN CANADA					

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON. CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D205-523-013	CHG	CHG002		
DESC.	Heli-Rappel Kit	STC	SH96-90		
LOT	B51057	STC	SR00511/2NY		
MODEL	Bell 205/212/214/412	STC	SR00513NY		
MADE IN CANADA					

# Work Order ID 52581

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Page 2

Item ID: D205-523-013

Accept

Revision ID: A

Item Name: Heli Rappel, 500lb

Start Date: 10/02/09 Start Qty: 4.00

Required Date: 10/09/09 Req'd Qty: 4.00

Reference: Return 2009/ RA109102

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

~~130~~ 140



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

New labels, decals, and paperwork are required with the new batch # @ CHG002.

Ensure kits are complete per the original w/o's attached.

*Per 10/07/09*

~~140~~ 130



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

*2) 501/1/09*

*(75) 1/1/09*

~~130~~



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

*Return to stock*

Memo

0.00

*N/A*

*Location*

**Work Order ID 52581**

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Page 3

Item ID: D205-523-013

Accept

Setup Start

Revision ID: A

Stop

Item Name: Heli Rappel, 500lb

Start Date: 10/02/09 Start Qty: 4.00

Cust Item ID:

Required Date: 10/09/09 Req'd Qty: 4.00

Customer:

Reference: Return 2009/ RA109102

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/08 J

~~REFERENCE ONLY~~

u 9-10-08

# Work Order ID 48671-1

July 2, 2009 3:00:35 PM



*SPIT V59*

Page 1

Item ID: D205-523-013  
Revision ID: A  
Item Name: Heli Rappel, 500lb

Accept



Setup Start



Stop



Start Date: 07/02/2009 Start Qty: 8.00  
Required Date: 07/17/2009 Req'd Qty: 8.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9301	Rev A

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file & type labels as per PPP D205-523-013, CHG 002								

*S 01/7/09*

REFERENCE ONLY

110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

*9/17/09 SC (X)*

120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

*=> S 01/7/09*

*(X) f*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 48671**

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Page 2

Item ID: D205-523-013  
Revision ID: A  
Item Name: Heli Rappel, 500lb

Accept

Setup Start

Stop

Start Date: 07/02/2009 Start Qty: 8.00

Required Date: 07/17/2009 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Memo

0.00

0.00

Identify and

Package as per PPP 205-523-013  
Stock Location: A

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

9/17 4051

09/07/20

MF 09-07-20

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

July 2, 2009 3:00:34 PM

Page 1

Work Order ID: 48671

Parent Item: D205-523-013RevA

Parent Item Name: Heli Rappel, 500lb

Comments:

Start Date: 07/02/2009

Required Date: 07/17/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-14A Bolt		Purchased	No			120	Each Y	79.0000	32.0000		9/17/7	SA

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	79	
	104547	2	
	106166	8	
	109282	19	
	111605	50	

AN960JD516 Washer		Purchased	No			120	Each X	1,603.000	64.0000		9/17/7	SW
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Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	1603	
	100564	2	
	106167	6	
	107534	34	
	107959	43	
	108246	46	
	108672	2	
	109059	49	
	109752	22	
	110363	46	
	110523	57	
	111279	296	
	112082	1000	

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 2, 2009 3:00:34 PM

Page 2

Work Order ID: 48671

Parent Item: D205-523-013RevA

Parent Item Name: Heli Rappel. 500lb

Comments:

Start Date: 07/02/2009

Required Date: 07/17/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D205-523-043RevN/A Slide Bar Assembly	4/	Manufactured	No			120	Each	1 0000	8.0000			

9/7/00 (42) SP

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
EG	1	
44841	1	

D2224RevF Rappel Anchor	2/	Manufactured	No			120	Each	11 0000	8.0000			
----------------------------	----	--------------	----	--	--	-----	------	---------	--------	--	--	--

50007 (42) SP  
9/7/7 SP

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	11	
17347	0	
40891	2	
41052	9	

D2229RevB Doubler	22	Manufactured	No			120	Each	11 0000	16.0000			
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Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	11	
33989	11	

9/7/9

41032 (92) SP  
9/7/7 SP  
B50015 (92) SP  
1533989 (42) SP

REFERENCE ONLY

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 3

Work Order ID: 48671

Parent Item: D205-523-013RevA

Parent Item Name: Heli Rappel, 500lb


Comments:

Start Date: 07/02/2009

Required Date: 07/17/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5  Nut		Purchased	No			120	Each	791.0000	32.0000			

9/7/7

8x SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

SI

791

110382

10

111127

281

111636

500

111 27

REFERENCE ONLY

July 2, 2009 3:00:34 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 48671 **2**

July 2, 2009 3:00:35 PM



5764 YK 54

Page 1

Item ID: D205-523-013

Revision ID: A

Item Name: Heli Rappel, 500lb

Start Date: 07/02/2009 Start Qty: **8.00Y**

Required Date: 07/17/2009 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI9301

Rev A

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy blue file & type labels as per PPP D205-523-013, CHG 002

801/4/22

110



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

801/7/22 (4)

120



QC4- 100% inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

=> 802/4/22

(X4) 6

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 48671**

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Page 2

Item ID: D205-523-013

Revision ID: A

Item Name: Heli Rappel, 500lb

Start Date: 07/02/2009 Start Qty: 8.00

Required Date: 07/17/2009 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Packaging

Package as per PPP D205-523-013  
Stock Location: D

Identify and

*Per 7/22 (4)*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*09/07/22**mt 09-07-22*

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Picklist Print**

July 2, 2009 3:00:34 PM

Work Order ID: 48671

Parent Item: D205-523-013RevA

Parent Item Name: Heli Rappel, 500lb

Comments:

Start Date: 07/02/2009

Required Date: 07/17/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ANS-14A Bolt		Purchased	No			120	Each 4	79.0000	32.0000		9/7/7	SA

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

79

104547

2

106166

8

109282

19

111605

50

120

Each

1,603.000 64.0000 16

82

11x  
21  
109282  
111605

9/7/7 SW

AN960JDS16

Washer

Purchased

No

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

1603

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

296

112082

1000

111279

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 48671

Parent Item: D205-523-013RevA

Parent Item Name: Heli Rappel, 500lb

Comments:

Start Date: 07/02/2009

Required Date: 07/17/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D205-523-043RevN/A	H	Manufactured	No			120	Each	1.0000	8.0000			
Slide Bar Assembly												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG

44841

1

1

120

Each

11.0000

8.0000

B50007 4X 9/17/22

9/17/12 30

D2224RevE	H	Manufactured	No									
Rappel Anchor												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

17347

40891

41052

11

0

2

9

120

Each

11.0000

16.0000

41032 (9x)

9/17/1

B50015

D2229RevB	KL	Manufactured	No									
Doublet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

33989

11

11

9/17/9

B33989 (7x)

REFERENCE ONLY

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

# Picklist Print

July 2, 2009 3:00:34 PM

Work Order ID: 48671

Parent Item: D205-523-013RevA

Parent Item Name: Heli Rappel, 500lb

Comments:

Component Item ID/  
Item Name

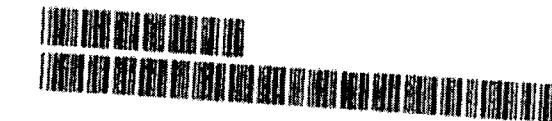
Replacement  
Item ID

Mfg/  
Purch

Purchased

MS21042L5

Nut



Start Date: 07/02/2009

Start Qty: 8.00

Required Date: 07/17/2009

Required Qty: 8.00

Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued
No			120	Each	791.0000	32.0000	

Date  
Issued

Status

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

791

110382

10

111127

281

111636

500

9/7/7

8x SF

11127

REFERENCE ONLY

July 2, 2009 3:00:34 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



REFERENCE ONLY

## 25.4 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

## 25.5 PARTS LIST

-013	-023	-043	Part No.	Description
X			D205-523-013	HELI-RAPPEL™ INSTALLATION
	X		D205-523-023	300 HOUR INSPECTION KIT
1		X	D205-523-043	SLIDE BAR ASSEMBLY
		1	D3011-1	RAPPEL SLIDE BAR
		2	33116	STUD FITTING
	2	2	MS21042L6	NUT (OR MS21042-6)
	2	2	AN960JD616	WASHER
	2	2	D3012-1	DECAL
	2	2	D3012-3	DECAL
	2	2	D3012-5	DECAL
1			D2224	RAPPEL ANCHOR
2			D2229	DOUBLER
4	4		AN5-14A	BOLT
8	8		AN960JD516	WASHER
4	4		MS21042L5	NUT (OR MS21042-5)

REFERENCE ONLY

48671

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Revision: 0

25-00-00  
Page 7 (8 blank) of 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_








NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries




# Work Order ID 51057

July 30, 2009 8:22:40 AM

Page 1

Item ID:	D205-523-013	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Heli Rappel, 500lb					
Start Date:	08/06/2009	Start Qty: 4.00		Cust Item ID:		
Required Date:	08/20/2009	Req'd Qty: 4.00		Customer:		
Reference:						
Approvals:	Process Plan: <u>mf</u>	Date: <u>09-07-30</u>	Tooling:		Date:	
	QC:	Date:	SPC (Y/N):		Date:	
				Run	Start	
					Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9301	Rev A								

100	DOCUMENT CONTROL	0.00						
								
DC								
Document Control	Memo	0.00						
	Photocopy blue file & type labels as per PPP D205-523-013, CHG 002							
110	Pick Kit	0.00						
								
Packaging								
Packaging	Memo	0.00						
120	QC4- 100% Inspect kits for completeness	0.00						
								
QC								
Quality Control	Memo	0.00						

REFERENCE ONLY

9/8/24 4056

→ 503/06/24

49

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51057



Page 2

July 30, 2009 8:22:40 AM

Item ID: D205-523-013

Accept



Setup Start



Revision ID: A

Stop



Item Name: Heli Rappel, 500lb

Start Date: 08/06/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/20/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D205-523-013 Stock <input type="checkbox"/> Location: <u>41</u>	<input type="checkbox"/> Identify and							
				Rev C					
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/8/24

09/08/25

MF 09-08-24

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 30, 2009 8:22:39 AM

Page 1

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Work Order ID: 51057



Parent Item: D205-523-013RevA



Parent Item Name: Heli Rappel, 500lb

Start Date: 08/06/2009

Required Date: 08/20/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S +4 D205-523-043RevN/A		Manufactured	No			110	Each	0.0000	4.0000			
Slide Bar Assembly												
S +4 D2224RevE		Manufactured	No			110	Each	10.0000	4.0000			
Rappel Anchor												

51057 SP  
50813 SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST489

10

50014

10

S  
+4 D2229RevB



Manufactured No

110

Each

34.0000

8.0000

Doubler

50875 9/6/21 @ SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST021

34

50812

34

#

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 2

July 30, 2009 8:22:39 AM

Work Order ID: 51057



Parent Item: D205-523-013RevA



Parent Item Name: Heli Rappel, 500lb

Start Date: 08/06/2009

Required Date: 08/20/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ANS-14A ANS-13A Bolt		Purchased	No			110	Each	93.0000	16.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>104547</div> <div>106166</div> <div>111605</div> <div>112243</div> <div>112314</div> <div>Loc Qty</div> <div>93</div> <div>2</div> <div>8</div> <div>13</div> <div>50</div> <div>20</div> <div>Loc Code</div> <div>M112243 (7)</div> <div>M112467 (9)</div> <div>(15X) M110363 50</div> <div>M108167</div> <div>112243 (7)</div>												
MS21042L5 Nut		Purchased	No			110	Each	1,639.000	16.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>110382</div> <div>111127</div> <div>111636</div> <div>112314</div> <div>Loc Qty</div> <div>1639</div> <div>10</div> <div>129</div> <div>500</div> <div>1000</div> <div>Loc Code</div> <div>M111636 9/18/21 (4)</div> <div>SP</div>												

REFERENCE ONLY

July 30, 2009 8:22:39 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 30, 2009 8:22:39 AM

Page 3

Work Order ID: 51057



Parent Item: D205-523-013RevA



Parent Item Name: Heli Rappel, 500lb

Start Date: 08/06/2009

Required Date: 08/20/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JDS16 		Purchased	No			110	Each	1,799.000	32.0000			

Washer

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

1799

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

44

112082

948

112314

500

112082

9/8/21

(42) 54

REFERENCE ONLY

July 30, 2009 8:22:39 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

## 25.4 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

## 25.5 PARTS LIST

-013	-023	-043	Part No.	Description
X			D205-523-013	HELI-RAPPEL™ INSTALLATION
	X		D205-523-023	300 HOUR INSPECTION KIT
1		X	D205-523-043	SLIDE BAR ASSEMBLY
		1	D3011-1	RAPPEL SLIDE BAR
		2	33116	STUD FITTING
	2	2	MS21042L6	NUT (OR MS21042-6)
	2	2	AN960JD616	WASHER
	2	2	D3012-1	DECAL
	2	2	D3012-3	DECAL
	2	2	D3012-5	DECAL
1			D2224	RAPPEL ANCHOR
2			D2229	DOUBLER
4	4		AN5-14A	BOLT
8	8		AN960JD516	WASHER
4	4		MS21042L5	NUT (OR MS21042-5)

REFERENCE ONLY

5/05/1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Location/Lot Activity

October 8, 2009 7:34:30 AM

Page 1 of 2

Criteria : All Items All Locations Lot: 51057 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Account Value Change	D205-523-013RevA / Heli Rappel, 500lb	Main Warehouse		FAUT01		9.0000		4.0000		
		FG			8/25/09	-9.0000	51057	-4.0000		-\$1,392.97
		Main Warehouse		FAUT01		9.0000		4.0000		
		FG			8/25/09	9.0000	51057	4.0000		\$1,392.97
		Main Warehouse		FAUT01		13.0000		4.0000		
		FG			8/25/09	-13.0000	51057	-4.0000		-\$1,392.97
		Main Warehouse		FAUT01		13.0000		4.0000		
		FG			8/25/09	13.0000	51057	4.0000		\$1,392.97
		Main Warehouse		FAUT01		17.0000		4.0000		
		FG			8/25/09	-17.0000	51057	-4.0000		-\$1,392.97
		Main Warehouse		FAUT01		17.0000		4.0000		
		FG			8/25/09	17.0000	51057	4.0000		\$1,392.97
Issue	D205-523-013RevA / Heli Rappel, 500lb	Main Warehouse	52581	MURD01		3.0000		0.0000		\$0.00
		Return 2009			10/02/09	-3.0000	51057	-3.0000		-\$1,044.73
								-3.0000		-\$1,044.73
RMA Inspect	D205-523-013RevA / Heli Rappel, 500lb	Main Warehouse	RA109102	MURD01		3.0000		3.0000		
		RMAInspect			10/02/09	-3.0000	51057	-3.0000	QC21	-\$1,044.73
		Main Warehouse	RA109102	MURD01		1.0000		0.0000		
		Return 2009			10/02/09	3.0000	51057	3.0000		\$1,044.73
RMA Receipt	D205-523-013RevA / Heli Rappel, 500lb	Main Warehouse	RA109102	MURD01		1.0000		0.0000		
		RMAInspect			10/02/09	3.0000	51057	3.0000		\$1,044.73
								3.0000		\$1,044.73

# Location/Lot Activity

October 8, 2009 7:34:39 AM

Page 1 of 2

Criteria : All Items All Locations Lot: 48671 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D205-523-013RevA / Heli Rappel, 500lb	Main Warehouse Return 2009	52581	MURD01		4.0000		1.0000		
					10/02/09	-1.0000	48671	-1.0000		-\$348.24
								-1.0000		-\$348.24
Rework	D2012-105RevDI / Arm	Main Warehouse ST	50710	LACE01		2.0000		1.0000		
					7/21/09	-2.0000	48671	-1.0000		-\$84.52
								-1.0000		-\$84.52
RMA Inspect	D205-523-013RevA / Heli Rappel, 500lb	Main Warehouse RMAInspect	RA109102	MURD01		4.0000		1.0000		
					10/02/09	-1.0000	48671	-1.0000	QC21	-\$348.24
		Main Warehouse Return 2009	RA109102	MURD01		0.0000		0.0000		
					10/02/09	1.0000	48671	1.0000		\$348.24
								0.0000		\$0.00
RMA Receipt	D205-523-013RevA / Heli Rappel, 500lb	Main Warehouse RMAInspect	RA109102	MURD01		0.0000		0.0000		
					10/02/09	1.0000	48671	1.0000		\$348.24
								1.0000		\$348.24
Shipment	D205-523-013RevA / Heli Rappel, 500lb	Main Warehouse FG	SO100042	GOLD01		4.0000		4.0000		
					7/20/09	-4.0000	48671	-4.0000		-\$1,392.97
		Main Warehouse FG	SO100227	BEDF01		4.0000		4.0000		
					7/22/09	-2.0000	48671	-2.0000		-\$696.48
		Main Warehouse FG	SO100274	BEDF01		2.0000		2.0000		
					7/22/09	-2.0000	48671	-2.0000		-\$696.48
								-8.0000		-\$2,785.94
WIP Receipt	D205-523-013RevA / Heli Rappel, 500lb	Main Warehouse FG	48671	FAUT01		0.0000		0.0000		
					7/20/09	4.0000	48671	4.0000		\$1,392.97